DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 99.28

WELDING INSPECTION REPORT

Resident Engineer: Casey, William
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-029654
Date Inspected: 05-Jun-2013

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: USA Hoist

OSM Arrival Time: 700
OSM Departure Time: 1530
Location: Crest Hill, IL

CWI Name: Robert Zimny

Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**CWI Present:**	☐ Yes	☑ No	
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Rod Oven in Use:**	☐ Yes	☐ No	☑ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☑ Yes	☐ No	☐ N/A
				Approved WPS:	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: SAS Tower Elevator

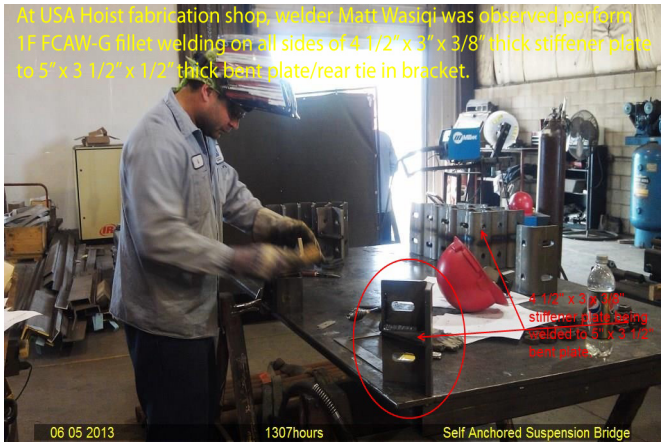
Summary of Items Observed:

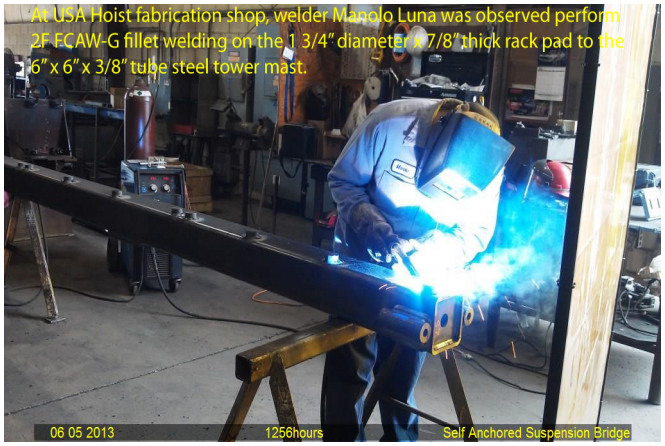
Caltrans Office of Structural Material (OSM) Quality Assurance Inspector (QAI) Joselito Lizardo was present at USA Hoist, Crest Hill, IL as requested to perform observations on the welding of components for the San Francisco Oakland Bay Bridge (SFOBB) Project.

At USA Hoist assembly shop, this QA randomly observed USA certified welder Manolo Luna who took over from Matt Wasiqi perform 2F (horizontal) position gas shielded Flux Cored Arc Welding (FCAW-G) welding ¼" fillet repair between 1 ¾" diameter x 7/8" thick rack pad to 6" x 6" x 3/8" thick tube steel tower mast. The welder was noted using gas shielded FCAW-G with 1.1mm E71T-1C/M-H8 Familiarc DW-50 wire electrode implementing USA Hoist Welding Procedure Specification FCAW 3210. The shielding gas being used was noted a combination of 75% Argon and 25% CO2 with flow rate of 40 CFH. During the shift, the working welding parameters was measured 27 volts and 200 amperes which deemed in compliance to the project requirements. At the end of the shift, fillet welding repair on the undersize ¼" fillet all around the rack pad was still continuing on various tower steel masts and should remain tomorrow.

At the same shop, this QA randomly observed USA Hoist welder Matt Wasiqi perform 1F fillet welding between the 4 ½" x 3' x 3/8" thick stiffener plate and 5" x 3 ½" x 1/2" thick bent plate rear tie in bracket. The ¼" fillet weld is being welded per USA shop drawing 914204-11. The welder was noted using gas shielded FCAW-G with 1. 1mm E71T-1C/M-H8 Familiarc DW-50 wire electrode implementing USA Hoist Welding Procedure Specification FCAW 3210. The shielding gas being used was noted a combination of 75% Argon and 25% CO2 with flow rate of 35 CFH. During the shift, the working welding parameters were measured 29 volts and 230 amperes which deemed in compliance to the project requirements. At the end of the shift, ¼" fillet welding on all sides of the

stiffener plate to the rear tie in bracket was still continuing and should remain tomorrow.





Summary of Conversations:

No significant conversation occurred today.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Gary Thomas 916-764-6027, who represents the Office of Structural Materials for your project.

Inspected By:	Lizardo,Joselito	Quality Assurance Inspector
Reviewed By:	Foerder,Mike	QA Reviewer